

Work Order ID 147569

Wednesday, June 08, 2016 2:26:54 PM

147569

Page 1

Item ID: D2529

Accept

N900040100

Setup Start ***NS1***

Revision ID:

DAS
13
9-89

Stop ***NS2***

Item Name: Washer

500

Start Date: 6/6/2016 Start Qty: ~~100.00~~

100

Cust Item ID:

Required Date: 6/8/2016 Req'd Qty: ~~100.00~~

100

Customer:

Reference:

Approvals: Process Plan: MLS Date: JUN 13 2016 Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2529	Rev E

100 0.00

100

PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 32698 Possible Supplier: Acklands, P/N: PFS FW14S1

500 JUN 14 2016

DAS
13
9-89

110 0.00

110

Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.33

Packaging

Ensure Material Release Note is attached

500X 8/16-6-20

120 0.00

120

QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

500

DAS
38
JUN 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐		Operator		Bending		Set-up		Folio/Program		Outside Dimensions
Doc/Data ☐		Offset/Setup		Centre Not Concentric		BOM/Route		Grain		Over/Under tolerance
Equip/Tooling ☐		Supplier		Cracks		Broken/Damage/Defect		Weld		Part Incorrect
Handling/Pre ☐		Training		Crimp/Kink/Ripple/Wave		Inspection Incomplete/Unqualified		Wrong Stock Pulled		Part Lost/Missing
Material ☐		Use for Testing		Cuffs		Contamination		Out of Sequence		Part Moved
Internal Transport ☐		Poor Information		Crushing		Countersink		Off-set		Drawing
Tribal Knowledge ☐		Rushing		Heat Treat		Cut Too Short		Mislabeled		Finish
LOA ☐		Product Improvement		Wave/Twist in Tube		Instructions Incomplete/Unclear		Fit/Function		Misread
Substation ☐		Process Improvement		Marks/Chatter		Drill Holes		Misaligned/off center		Turning Sequence
Past Expiry Date ☐		Manufacturing Process	OTHER : _____							
Misidentified ☐		Past Due								

1 47569

Wednesday, June 08, 2016 2:26:54 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

Stop ***NS2***

100

100

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Identify as per dwg & Stock Location: Y004

130

525

6
9-89

JUN 22 2016

0.00

140

1.67

MCS JUN 22 2016

ML5 JUN 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

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147569

D2529

Required Qty: 100.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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PFS-FW14S1

WASHER

**

$500 \times 500 = 250,000$

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

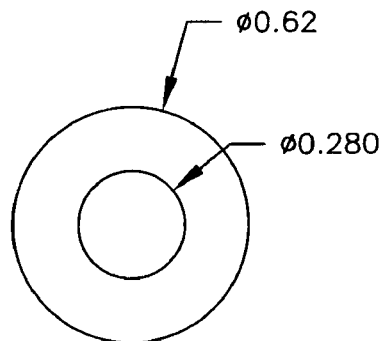
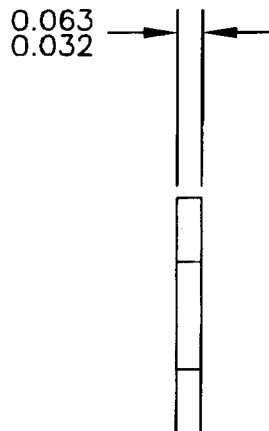
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D2529	REV. E SHEET 1 OF 1
DATE 07.04.17		TITLE WASHER	SCALE 2:1
A	95.12.22	NEW ISSUE	
B	96:08:28	ADD SS	
C	97:03:24	RE-DESIGN, CHANGE MATERIAL SPEC.	
D	97.10.14	CHANGE THICKNESS (TSR A144)	
E	07.04.17	UPDATE DRAWING NOTES	

RELEASED
07.06.28 *PH*

STO. COPY
RETURN TO
ISSUING
UNCONTROLLED COPY
SUBJECT TO REMOVAL
W/OUT NOTICE
NO. 145092105
1606-13

D2529 WASHER

- 1) MATERIAL: AISI 303 OR AISI 304/316 STAINLESS STEEL
(REF DART MATERIAL SPEC M303R OR M304R)
- 2) POSSIBLE SUPPLIER: ACKLANDS, P/N: PFS FW14S1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010 MAX

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO32698

Purchase Order Date 6/14/2016 1:47:32 PM

PO Print Date 6/16/2016

Page Number 1 of 2

Order From :

VC-ACK001

Ship To : DART AEROSPACE LTD

ACKLANDS - GRAINGER INC.
P.O. BOX 2970
WINNIPEG, MB R3C 4B5
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED

Contact Name

Buyer

Chantal Lavoie

Vendor Phone

613 632 2739

Customer POID

Customer Tax #

10127-2607

Ship To Contact

Terms

Net 30

Ship To Phone

Currency

CAD

Ship Via:

VENDOR'S TRUCK

FOB

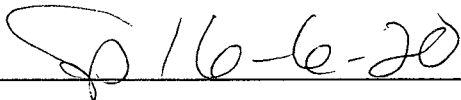
FOB - (Free on Board)

Ship Acct:

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
Line Comments		Promise Date					
Delivery Comments							
1	PFS-FW14S1	WASHER	6/20/2016		500.00	\$0.03	\$14.80
			Yes		Each		
			6/20/2016				
AS PER DWG D2529 REV. E B147569							
						Line Total:	\$14.80
6	71401-45	PROCUREMENT QUALITY CLAUSES	6/20/2016		1.00	\$0.00	\$0.00
			No				
			6/20/2016				
Procurement Quality Clauses A005 RIGHT OF ENTRY A026 CERTIFICATION OF MATERIAL CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENTS							

Note:

6/16/2016

		ACKLANDS-GRAINGER INC. 4475 GRIFFITH		Acklands-Grainger tax ID / N° taxe : 88970-1272/TVQ# 1019602903		PACKING SLIP / BORDEREAU D'EXPÉDITION  32698							
		SAINT-LAURENT QC H4T 2A2 (514) 332-6100 www.acklandsgrainger.com		Customer tax ID / N° taxe du client:								Customer PO / Du client PO:	
				Contact / Contact: LAVOIE (613)632-9577									
Sold to / Vendu a: 886364568 DART AEROSPACE LTD: DART AEROSPACE LTD VMI 1270 ABERDEEN ST HAWKESBURY ON K6A 1K7 CA				Ship to / Adresse d'expédition: 886364568 DART AEROSPACE LTD DART AEROSPACE LTD VMI 1270 ABERDEEN ST HAWKESBURY ON K6A 1K7 CA				Delivery / Livraison:  6327702407					
Shipping conditions / Conditions d'expédition: Ship		Incoterms / Incoterms: Free on board,ORIGIN		Payment terms / Conditions de paiement: Net 30 days after invoice date		Account manager / Directeur des comptes: 350090		Order / Commande 1264897374		Delivery date / Date d'envoi: 06/15/2016		Order date / Date de la commande: 06/15/2016	
Requisitioner / Demandeur:		Freight terms / Modalités de fret: Prepaid and Add		Carrier / Transporteur:		Notes / Remarques:							
Line / Ligne	PO line / Ligne de BC	Material / Matériau	Customer material / Matériau du client	Description / Description			Ship quantity / Quantité	Order quantity / Quantité commandée	UoM / Unité de mesure	Unit price / Prix unitaire	Per / Par	Extended price / Prix total	
000010		FPBU51205.025.0001		FLAT WASHER SS304 0.281X0.625			500.000	500.000	EA	2.96	100	14.80	
							Freight / Fret			0.00			
00:00:00							Subtotal / Total partiel			14.80			
Received by / Recu par: 							PST/QST / TVP/TVQ			0.00			
							HST/GST / TPS/TVH			1.92			
							Order total / Total de la commande			16.72			